

Date: Friday, 01/08/2008 3:32:45 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BACKER PLATE
<b>Job Number</b> :	40983		
<b>Estimate Number</b> :	13537		
<b>P.O. Number</b> :		<b>Part Number</b> :	D31911
<b>This Issue</b> :	01/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3191 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
	<b>Type</b> :	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/08/2008
<b>Checked &amp; Approved By</b> :	Qty: 5 Um: Each		
<b>Comment</b> :	Est Rev:A 08-08-01 new issue DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 0.1313 sf(s)/Unit Total : 0.6563 sf(s)  
 6061-T6 .063 Sheet  
 batch: 108279 HB 8-8-13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3191  
 Dwg Rev: A  
 Prog Rev: A

HB 8-8-13

(6)

2-Deburr if necessary

HB 8-8-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-8-13

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/08/13 (x6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(6x)

**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

M-f 08/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 3:32:45 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKER PLATE

Job Number: 40983

Part Number: D31911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M1106442



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

3:20

OVEN TEMPERATURE:

320 °F

FINISH TIME:

3:50

mf 08/08/13

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08-13

(6x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(6x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 75

8/8/14

SV

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



mf 08-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

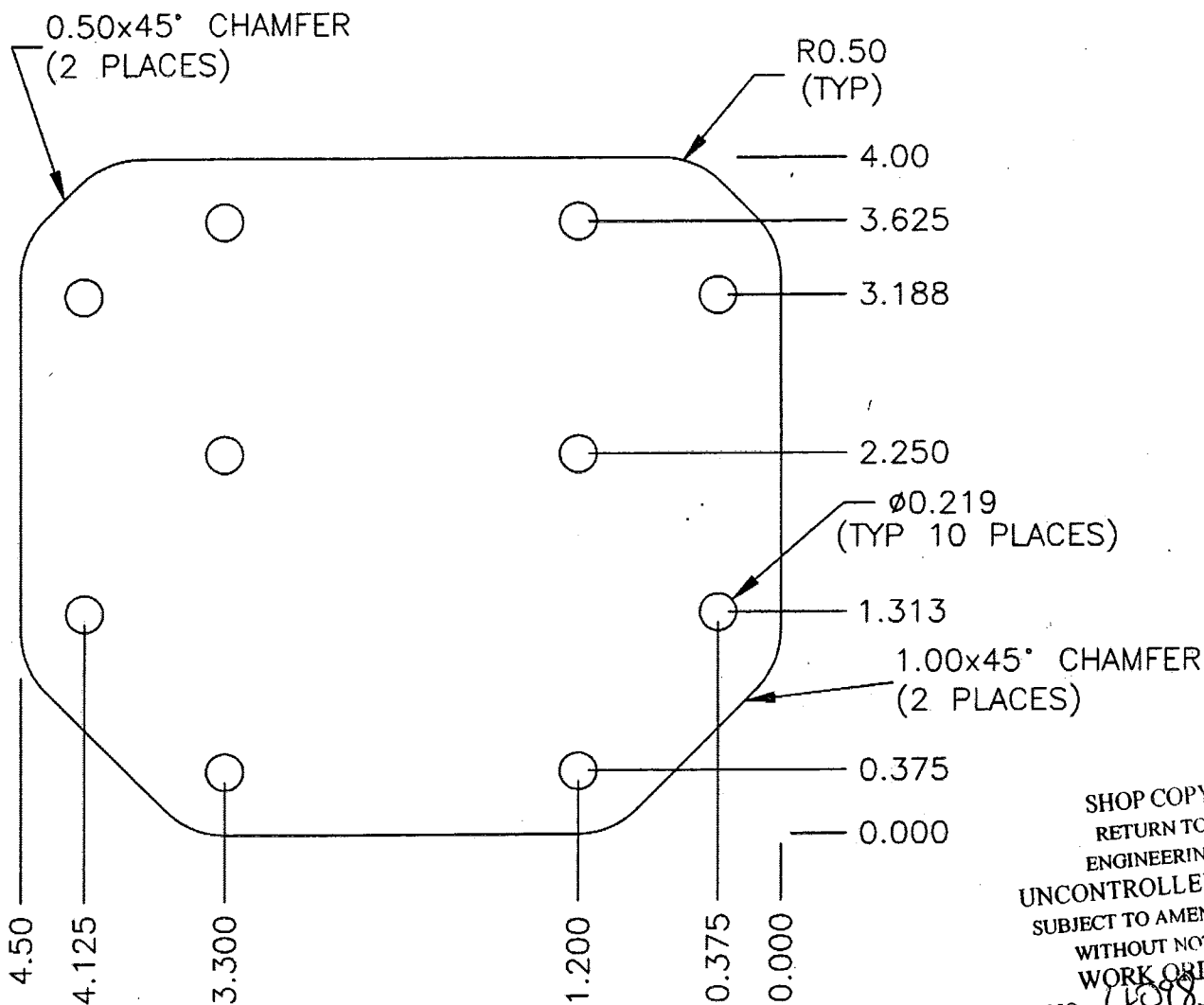
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3191	REV. A SHEET 1 OF 2
DATE 03.05.27	TITLE BACKER PLATE		SCALE 1:1
A	03.05.27	NEW ISSUE	

RELEASED  
#03.07.09



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WORK ORDER  
NO. 4083

**D3191-1 BACKER PLATE**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.063 THICK (REF DART SPEC. M6061T6S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

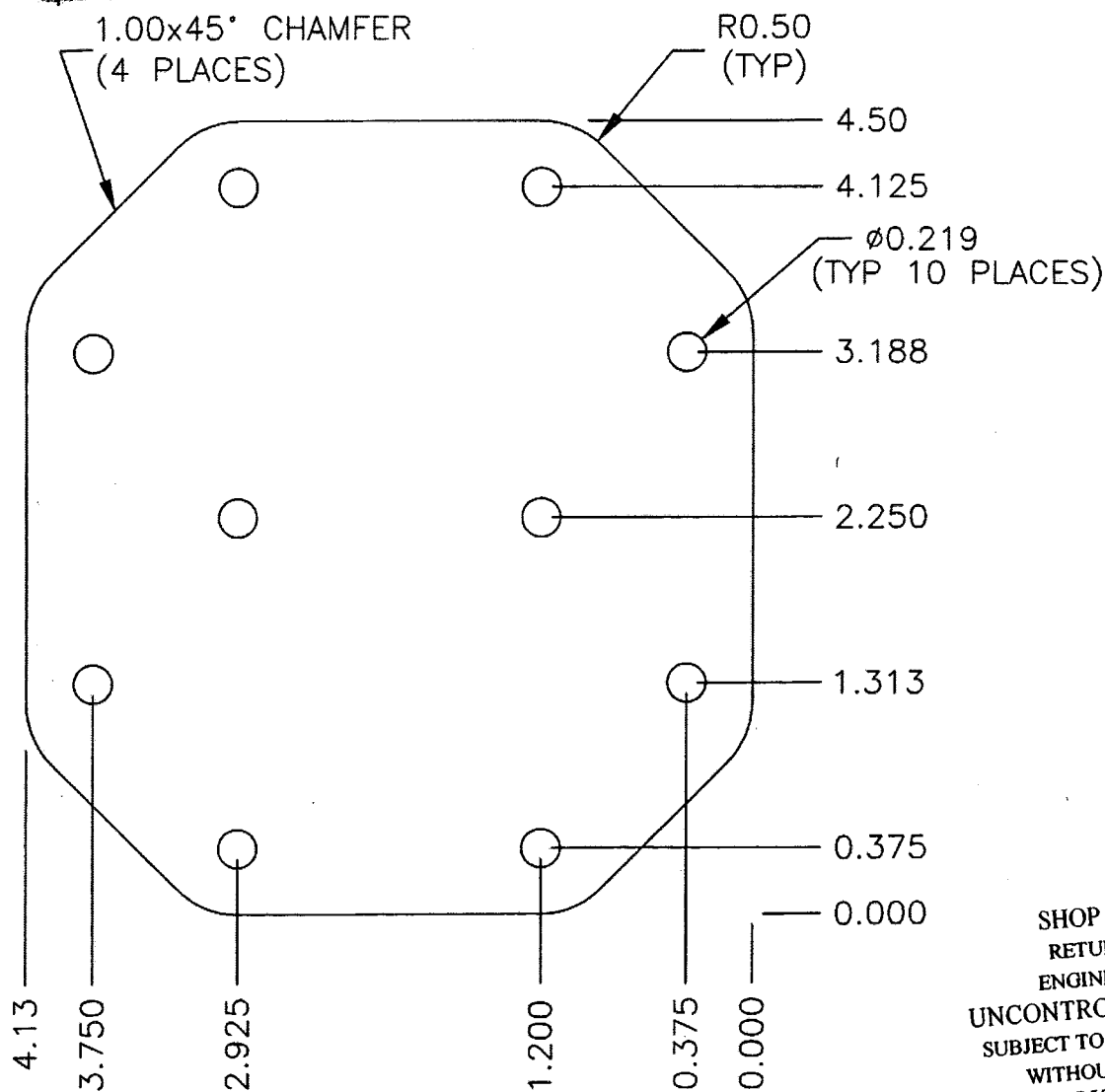
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3191	REV. A SHEET 2 OF 2
DATE 03.05.27		TITLE BACKER PLATE	SCALE 1:1

RELEASED  
# 3.07.09



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WITHOUT NOTICE  
WORK ORDER  
NO. 40983

**D3191-3 BACKER PLATE**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11); 0.063 THICK (REF DART SPEC. M6061T6S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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